

Work Order ID 53268

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Item ID:	D2724-041	Accept		Setup	Start	
Revision ID:	C				Stop	
Item Name:	206L Step Assembly					
Start Date:	29/10/2009	Start Qty: 4.00		Cust Item ID:		
Required Date:	09/11/2009	Req'd Qty: 4.00		Customer:		
Reference:						

Approvals:	Process Plan:		Date:	09-10-30	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2724	Rev C								
100	Large Fab	0.00							
	Large Fab								
Large Fab	Memo	0.00			SAD 09-10-30				
Large Fab	Cut D2724-1 using D2622 extrusion as per Dwg D2724 □ Debur and bevel ends for welding								
110	Large Fab	0.00							
	Large Fab								
Large Fab	Memo	0.00			09-10-03				
Large Fab	Weld end cap and lugs as per Dwg D2724 using Jig DT8884 followed by Jig □ DT (One End Only) □ A/R AL ROD								
	Batch: M111311 □ Grind end cap welds flush								
	M111494								
120	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	QC								
Quality Control	Memo	0.00							
					PD 09.11.05				

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Item ID: D2724-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: 206L Step Assembly

Start Date: 29/10/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

⇒ 8 or 10.5

0.00

144



QC

Memo

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

1/2 09-11-05

0.00

4

0



HandFinish

Memo

Hand Finishing

150

QC3- Inspect Part Finish

0.00

SAD
09-11-05

0.00

4



QC

Memo

Quality Control

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Accept

**Setup Start**

Stop

[illegible]**Cust Item ID:**

Customer:

Reference:

Run Start



Stop



Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

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Item ID: D2724-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: 206L Step Assembly

Start Date: 29/10/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

pressure wash

0.00

→ 41 09/11/09

X4614

B

Hand Finishing

Memo

205

0.00



SprayPaint

Memo

0.00

Spray Painting

PRIME - GREY 110918
SPRAY PAINT DELFLEET BLUE 115177
CLEAR DELFLEET 110896

ml 09 11 17 (4)

215

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

25 09-11-18 (4)

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Item ID: D2724-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: 206L Step Assembly

Start Date: 29/10/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 09/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/19

09-11-19

Picklist Print

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Work Order ID: 53268



Parent Item: D2724-041RevC



Parent Item Name: 206L Step Assembly

Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3458-3RevA		Manufactured	No			100	Each	13.0000	8.0000			
Step Mounting Plate												

12 09.11.03

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

13

51240

13

8

D2622-120CRevC1

Manufactured

No



Step Extrusion

110

Each

147.9200

4.0000



SAP 09-10-30

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

WA

147.92

48612

38.92

52026

109

4

D2734RevC

Manufactured

No



Step End Plate

110

Each

65.0000

8.0000



12 09.11.06

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

ST

65

43535

2

48110

63

8

Picklist Print

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Work Order ID: 53268



Parent Item: D2724-041RevC



Parent Item Name: 206L Step Assembly



Start Date: 29/10/2009

Required Date: 09/11/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3458-1RevA		Manufactured	No			110	Each	19.0000	8.0000			
												
Step Mounting Plate												

09.11.03

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

ST

19

51239

19

8

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Shop Packet Print

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SHOCKLEY
R. ENG.
UNCONT
SUBJECT TO DART AND DART
WITH PART NUMBER

DART

NO. 53245
WORK ORDER

RELEASED

05.11.14

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004

APPLY BLACK
ANTI-SKID ON
TOP SURFACE
TO BOTTOM
OF TOP RADIUS

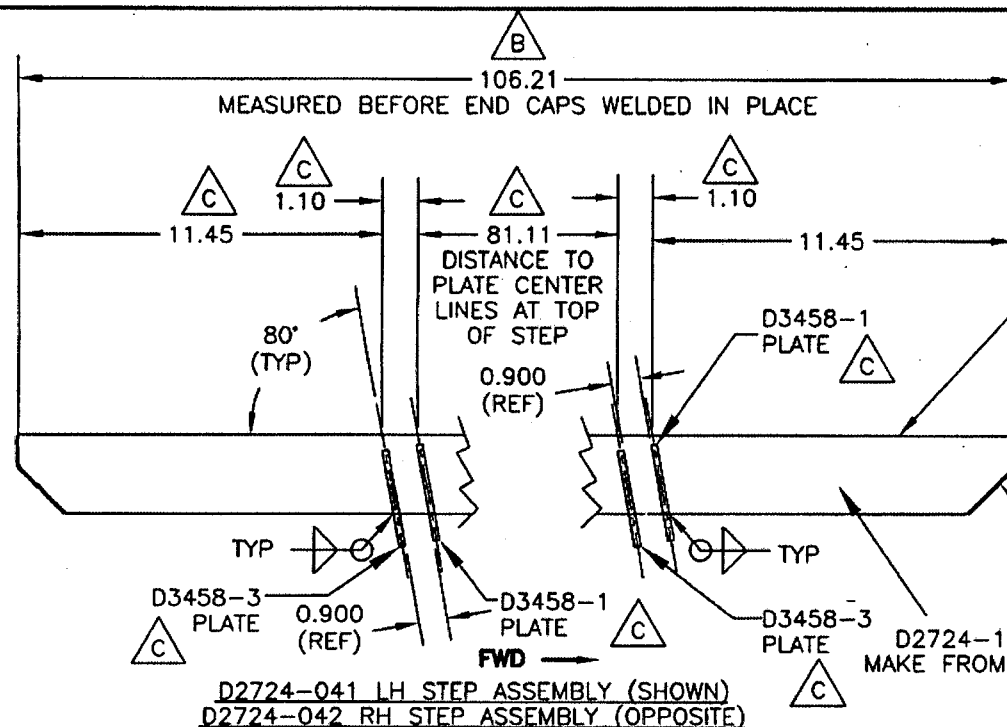
REFER TO STEP
END DETAIL

D2724-1
MAKE FROM EXTRUSION D2622-107

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE

D2734 END PLATE

TYPICAL STEP END DETAIL
NOT TO SCALE



D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.	PORT HADLOCK, WA	REV. C
CHECKED		APPROVED		DRAWING NO.	D2724	SHEET 1 OF 1
DATE	05.09.19	TIME		206L/407 STEP ASSEMBLY		SCALE
				NEW ISSUE		NTS
				UPDATED WELD DETAIL REVISED TOLERANCES		
				RE-DESIGN, ADD D3458-1/-3		